

Work Order ID **51885**

Tuesday, September 08, 2009 3:15:58 PM



Page 1

Item ID: D350-748-201

Revision ID: D

Item Name: Crosstube Installation, High Aft

Start Date: 9/9/2009 Start Qty: 1.00

Required Date: 9/29/2009 Req'd Qty: 1.00

Reference:



Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: *[Signature]* Date: *09-09-08* Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
N/A	Rev D								

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD350-748-201

CHG001

S. J. J.

110

0.00



BENDING MACHINE - CROSSTUBES

CNC Bend 2

Memo

0.00

CNC Alpha 160 Bender

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and
Folio FT _____



[Signature]

MP 10-01-14

120

0.00



QC15- Crosstube Dimensional Check

QC

Memo

0.00

Quality Control

CP

10.01.14

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Accept



Setup Start



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Stop



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Start Date: 9/9/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/29/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Crosstubes

Crosstubes

Crosstubes

Memo

0.00

1-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,
Set-up drill table as per QSI 010

2-Deburr

3-Engrave Part # and Batch # as per Dwg D350-748-241

4-Remove all marks from tube within limits of D350-748-241 Q.M. 10-01-27

5- Apply a light coat of LPS3 on the interior of tube

Batch:

107956

AWM 10-1-28

140



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

Batch # 0 engraved
Memo

0.00

2) 8 crosstubs

42

Abstract

Tuesday, September 08, 2009 3:15:58 PM

Accept

Setup Start

Stop

[illegible]**Cust Item ID:**

██████████
██████████
██████████

Customer:

Reference:

Run Start

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

PL 10-2-01

Outsource3

Outsource process - Cad plate

Outsource process-Cadplate per QSI017 4.1.9.1

0.00

Memo

Issue P/O:

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

0.00

160

Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

Ensure certificate of conformity is attached

0.00

170

[REDACTED]

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

10 04 20 1

Work Order ID 51885

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Reference:

Cust Item ID:







Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	SprayPaint	0.00					10	04	20 ①
	SprayPaint	0.00							
	Spray Painting								
	Memo								
	1-Prime inside crosstube as per QSI 005 4.2								
	2-Paint Outside of Tube as per Dart QSI 005 4.2								
190 	QC14- Inspect Spray Paint	0.00					10	04	21 ①
	QC	0.00							
	Quality Control								
	Memo								
	Then, Wrap in plastic bag to protect from scratches								
200 	Crosstubes	0.00					10	04	21 ①
	Crosstubes	0.00							
	Crosstubes								
	Memo								
	1-Install Ground wire Insert, then insert screw and washer								
	2-Install Abraison strips as per Dwg D350-748-241 & QSI 035.								
	3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS								

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Required Date: 9/29/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8/10/09/11

Memo

0.00

(H)

220



Packaging

Packaging

Pick Kit

0.00

Memo

0.00

10-4-28 SP

230



QC

Quality Control

QC4- 100% Inspect kits for completeness

0.00

8/10/09/11

Memo

0.00

(H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-748-201 PAR #: NCR 10-026 Fault Category: Cross tubes NCR: Yes No DQA: 10/05/11 Date: 10/05/11
 Resolution: Accepted Disposition: use as is QA: N/C Closed Date: 10/05/12

NCR: <u>51885</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/05/10</u>		<u>NCR 10-026 - to verify</u> <u>the cross tubes, to ensure they</u> <u>are good, remove the cracking.</u> <u>on above NCR.</u>	<u>CP</u> <u>10.05.10</u> <u>per</u> <u>QSI 042</u>	<u>bad test for bond's until</u> <u>ref NCR 10-026</u>	<u>10/05/10</u>	<u>CP</u> <u>10.05.10</u> <u>per</u> <u>QSI 042</u>	<u>10/05/12</u>	<u>10/05/10</u>
			<u>CP</u> <u>10.05.10</u> <u>per</u> <u>QSI 042</u>	<u>pickup / repaint as necessary</u> <u>replace abrasion strip if</u> <u>necessary</u>	<u>ml</u> <u>10.05.10</u>	<u>S</u> <u>10/05/10</u>	<u>10/05/12</u>	<u>10/05/10</u>

NOTE: Date & initial all entries

L Lacelle

From: David Shepherd [dshepherd@dartaero.com]
Sent: April 27, 2010 3:40 PM
To: 'Mike Petsche'
Cc: 'Bill Beckett'; 'L Lacelle'; 'Chris Provencal'; 'Dan Stow'; ssheldon@dartaero.com
Subject: 350 crosstubes

Mike,

I discussed the 350 crosstube load testing with Bill a little while ago and this plan makes sense to him.

So, my recommendation to clear these crosstubes is to load the fwd crosstubes to 3500 lb and the aft crosstubes to 3000 lb in the deflection test rig and document on the work orders that this test has been completed. Hold max load for 1 minute. Per TP-D350-748-2, these loads represent the maximum load on these crosstubes at gross weight and are below the yield point of the material. I would like to request that Chris Provencal witness these tests and sign off the work orders based on his experience with Dart landing gears. My feeling is that if there is a problem with the parts, it will manifest itself during this load test. I, for one, would feel a lot more confident in testing each crosstube in this manner than relying totally on what Exova has to say. I think it would be very difficult to reach a conclusion on the whole batch on the basis of cracks in two parts from the batch.

I believe that we can accomplish this before next Friday, which also gives us time to hear what Exova has to say in case it has an impact on our decision. So far, what I have seen from Exova shows me that there are fluctuations in the heat treating but the tubes are heat treated to our specification.

For this reason, I believe we should tell DHS that it looks like we will be able to start shipping 350 crosstubes by May 7th pending a successful Engineering test of the material.

David.

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Item ID: D350-748-201

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Start Date: 9/9/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 9/29/2009 Req'd Qty: 1.00

Customer:



Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-748-201								
	Location: _____								
	PPP Rev: <u>A</u>								
250									
	QC21 - Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE 10/05/11 AUTH [Signature]RELEASED [Signature] DATE 10-05-11see w/o pcode
CDs sign off

1005.11

u 1005.11

Picklist Print

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Work Order ID: 51885



Parent Item: D350-748-201RevD



Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D350-748-201TRNRevD		Manufactured	No			110	Each	4.0000	1.0000			

D350-748-201TRNRevD



Crosstube Turning Detail



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FG

47167

47170

47171

47172

4

1

1

1

1

DP

10-1-14

ALS4-1032-225

Purchased

No

200

Each

8,753.000 1.0000



Insert



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

107441

110768

8753

16

8737

10-04-21

Picklist Print

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Work Order ID: 51885



Parent Item: D350-748-201RevD



Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10 		Purchased	No			200	Each	8 2,309.000	1.0000			
Washer												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 2309

105442 95

109059 2

109840 23

110985 202

111279 13

111668 70

112314 1000

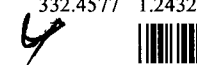
112369 904

D2856-400RevA Manufactured, No



200 f

332.4577 1.2432



Abraison Strip

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 122.8077

42437 44.93

46543 77.8777

Main Warehouse

ST403 209.65

50593 209.65

B# 56626

1- cut as per dwg D2856

10.04.21

10.04.21

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Shop Packet Print

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Picklist Print

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Work Order ID: 51885



Parent Item: D350-748-201RevD



Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3502-1RevB		Manufactured	No			200	Each	43.0000	2.0000			
Support												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

5

41603

2

42968

2

47120

1

Main Warehouse

ST168

38

50287

38

MS21920-20

Purchased

No

200

Each

117.3000

2.0000



Clamp (per MIL-DTL-8783C)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

117.3

103478

2

106484

12

109269

9.3

110536

10

111281

34

112307

50

M/ 10-04-21

M/ 10-04-21

B# 52903

B# 112793

Picklist Print

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Work Order ID: 51885



Parent Item: D350-748-201RevD



Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-10 		Purchased	No			200	Each	37.0000	1.0000			
Screw												

5# 112794

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

37

111425

37

10.04.21

AN4-41A



Purchased

No

220

Each

142.0000 8.0000



1110731 10.4.28

Bolt

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

142

105940

4

110363

16

110731

50

111424

50

112082

22

Picklist Print

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Work Order ID: 51885



Parent Item: D350-748-201RevD



Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN4-6A		Purchased	No			220	Each	814.0000	16.0000			
--------	--	-----------	----	--	--	-----	------	----------	---------	--	--	--



Bolt



M112229 10-4-28 SP

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	814	
102602	3	
105810	15	
107534	1	
109545	2	
110399	27	
111279	466	
112314	300	

AN5-32A

Purchased

No

220

Each

79.0000

4.0000



Bolt



M113121 10-4-28 SP

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST	79	
106242	3	
106519	4	
110363	17	
111916	5	
112082	50	

Picklist Print

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Work Order ID: 51885



Parent Item: D350-748-201RevD



Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN960JD416

Purchased

No

220

Each

8,758.000

32.0000



Washer AA5114900463



M113706 10-4-285

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8758

102929

2

105906

4

107321

23

107939

114

108161

553

108827

31

109249

69

110523

340

111279

115

111916

2620

112314

4887

16941

0

Picklist Print

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Work Order ID: 51885



Parent Item: D350-748-201RevD



Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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AN960JD516

Purchased

No

220

Each

1,209.000 8.0000



Washer NAS1149005634



M113706 16-4-28 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1209

100564

2

106167

6

107534

34

107959

43

108246

46

108672

2

109059

49

109752

22

110363

46

110523

57

111279

43

112082

359

112314

500

D3500-1RevC

Manufactured

No

220

Each

17.0000 4.0000



Saddle



~~125565~~ 10-4-28 SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

17

47119

12

47350

5

4

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Parent Item Name: Crosstube Installation, High Aft

Start Date: 9/9/2009

Required Date: 9/29/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3501-1RevA

Manufactured

No

220

Each

423.0000

16.0000



Bushing



4512

10-4-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

423

45402

19

45918

200

48268

204

14

MS21042L4

Purchased

No

220

Each

8,308.000

24.0000



Nut



M114108

10-4-28

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8308

107499

5

110507

266

111827

5996

112314

2000

15924

0

8182

41

Picklist Print

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Required Date: 9/29/2009

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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MS21042L5		Purchased	No			220	Each	1,337.000	4.0000			
-----------	--	-----------	----	--	--	-----	------	-----------	--------	--	--	--



Nut



M113537 10-4-09

SL

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1337

110382

10

111636

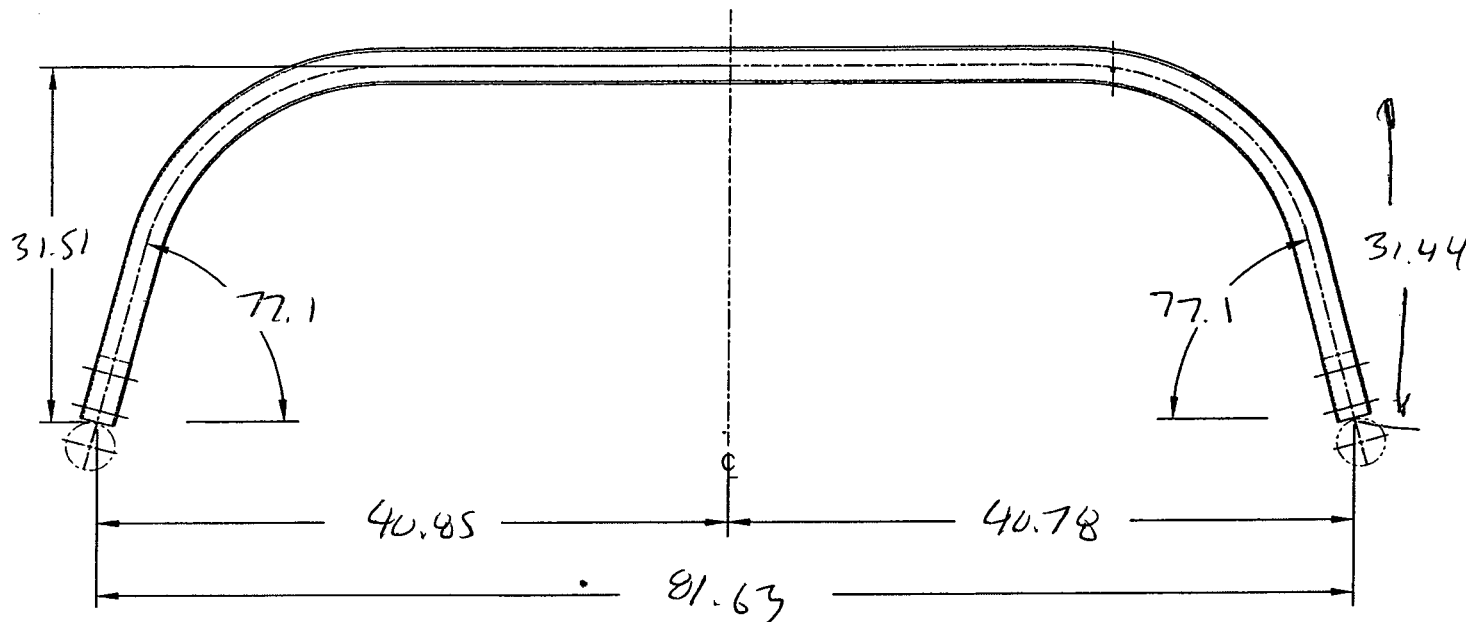
327

112314

1000

DART AEROSPACE LTD	Work Order: 51885	
Description: Crosstube High Aft (AS350/355)	Part Number: D350-748-201	
Inspection Dwg: D350-748-241	Rev: D	Page 1 of 1

Required Dimension	Min	Max
Height	31.22	31.48
1/2 Span	40.77	41.03
Angle	75	77
Total Span	81.54	82.06



Comments
ANGLE HIGH, ACCEPTABLE 10.01.14
TWIST = 0.000"

QC15 Inspection	10.01.14
Date	

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	

DART**RELEASED**

06.10.31

DESIGN 90	DRAWN BY 90	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D350-748-241	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6018-125 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

QTY	P/N	DESCRIPTION
X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
1	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

D350-748-141 CROSSTUBE:

- MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125
FINISHED LENGTH = 122.70±0.06
- MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS
- BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- ALL DIMENSIONS ARE IN INCHES
- PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

UNDER REVIEW

09.02.05

PER PCR 09-001

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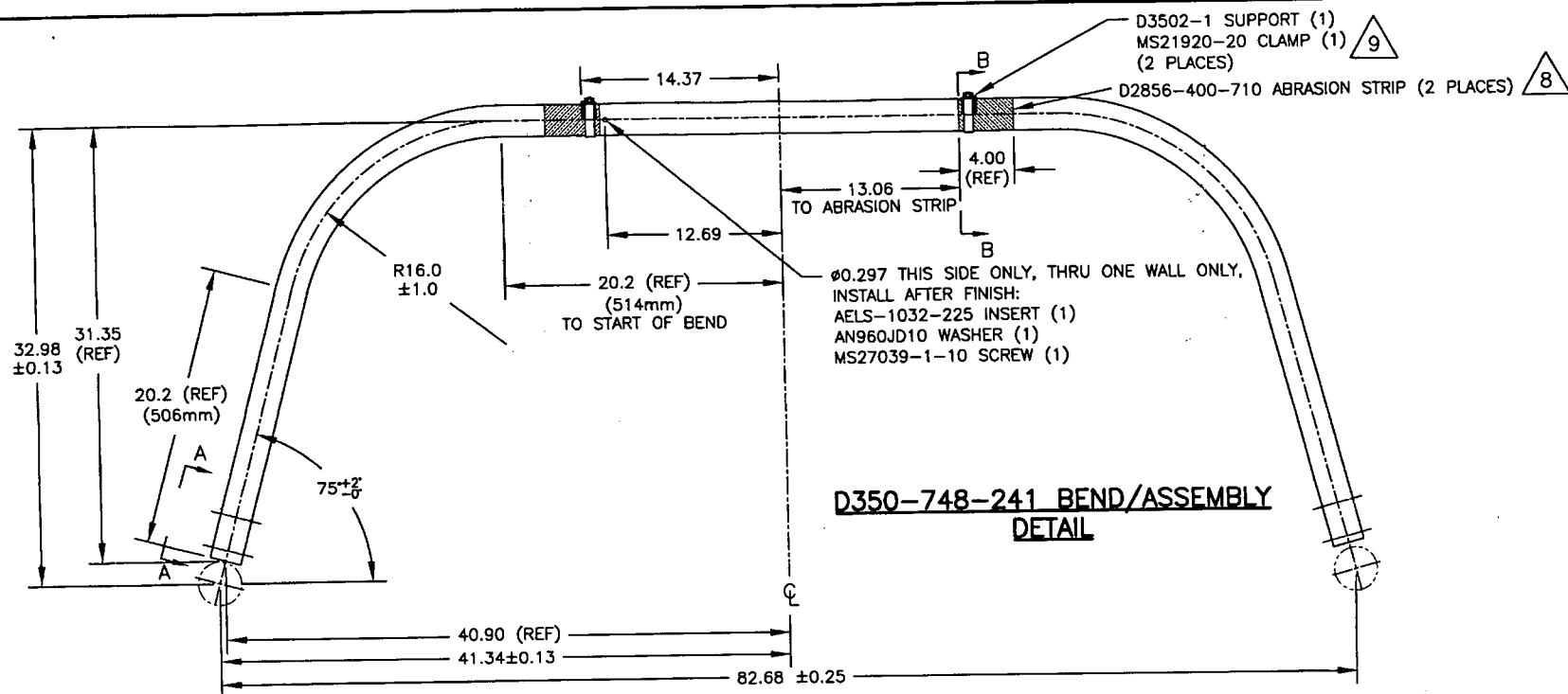
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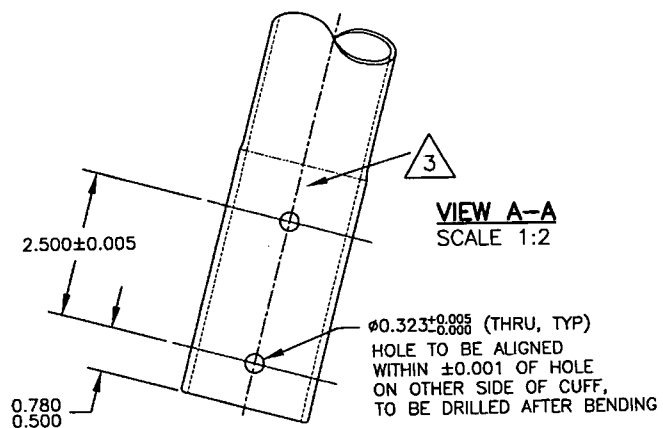
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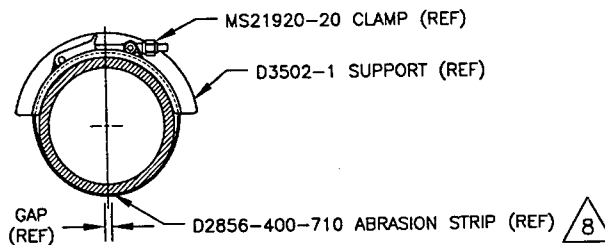
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D350-748-241 BEND/ASSEMBLY DETAIL



SECTION B-B SCALE 1:2



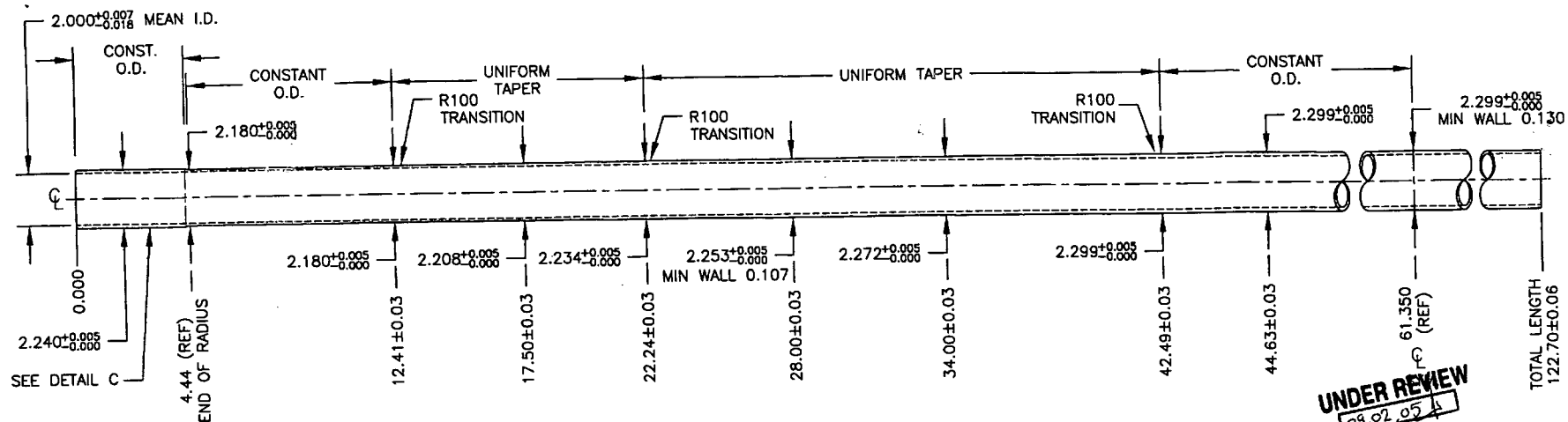
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		DATE	06.10.31			D350-748-241	SHEET 2 OF 3
						TITLE	SCALE
						CROSSTUBE (AS 350/355 HI AFT)	1:8

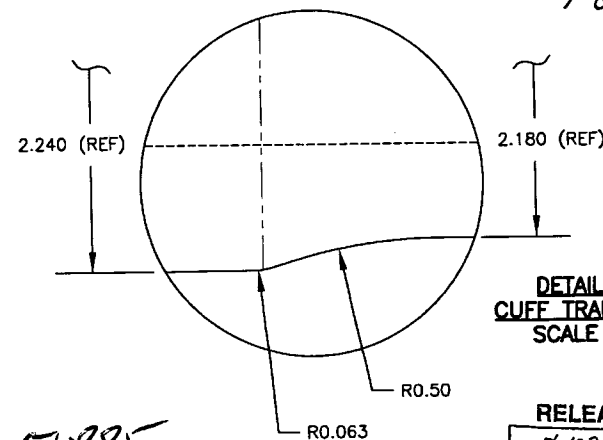
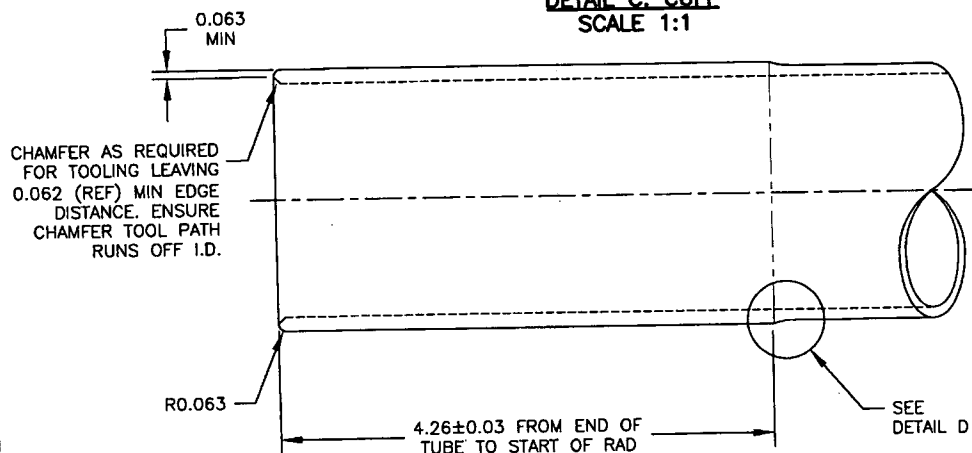


D350-748-241 MACHINING DETAIL

UNDER REVIEW
09.02.05

UNDER REVIEW
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DETAIL C: CUFF SCALE 1:1



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**CERTIFICATE OF
CONFORMANCE**

**CADORATH PLATING CO. LTD.
2150 LOGAN AVENUE
WINNIPEG, MANITOBA R2J-0J1**

DATE: Feb-22-2010

**CONSIGNED TO: Dart Aerospace Ltd.
1270 Aberdeen St
Hawksbury, ON K6A 1K7**

W/O #: 93268

INVOICE #: 48326

**CONTRACT OR
PURCHASE ORDER # 513885**

DESCRIPTION: SKID

QTY 1

P/N # D350-748-201

S/N # B51835

**STRESS RELIEF BAKED @ 375 DEG. FOR 5 HRS. BAKE HEAT
CHART #10-116. MPI INSPECTED IAW ASTM-E-1444. CADMIUM
PLATED IAW AMS-QQ-P-416B, TYPE 2 YELLOW, CLASS 1. BAKE
HEAT CHART #10-169.**

**CERTIFICATE: I certify that the items indicated here on have
been inspected and tested and conform to all specifications
and requirements detailed on the contract or purchase order.**

Approved Inspector:

